

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029082**Date Inspected:** 31-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Welder Chris Bruce #8901:**

The welder was observed Carbon Arc Gouging (CAG) and performing the weld repairs on excavations on the Electroslag Weld "M" W-042 at face B. The indications were rejected with Ultrasonic Testing Shear Wave and were excavated at Y locations 9390 and 9460 as per Request for Weld Repairs or the RWR 201301-044 & 045. The welder was observed preheating the weld to 300 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized the Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector William Sherwood throughout the day and they appeared to be in compliance with the WPS noted above.

**Welder Eric Sparks #3040:**

The welder was observed performing the weld repairs on excavations on the Electroslag Weld "L" S-042 at face B. The indication was rejected with Ultrasonic Testing Shear Wave and was excavated at Y location 7460 as per Request for Weld Repairs or the RWR 201301-047. The welder was observed preheating the weld to 300 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized the Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector William Sherwood throughout the day and they

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appeared to be in compliance with the WPS noted above.

Welder James Zhen #6001:

The welder was observed excavating the Electroslag Weld "F" E-045 at face A, in 1mm increments at the Y location 7110. Each of the 1mm excavation was performed with a grinder and was Magnetic Particle Tested (MPT) and photographed by QC Inspector Fred Michaels and this QA . The excavation continued at 36mm deep from the previous shift until a depth of 40mm at the end of the shift. This concluded the grinding excavation at this Y location, and the welder was observed relocating and setting up at another weld location. The welder was observed grinding the entire shift.

Non-Destructive Testing (NDT)

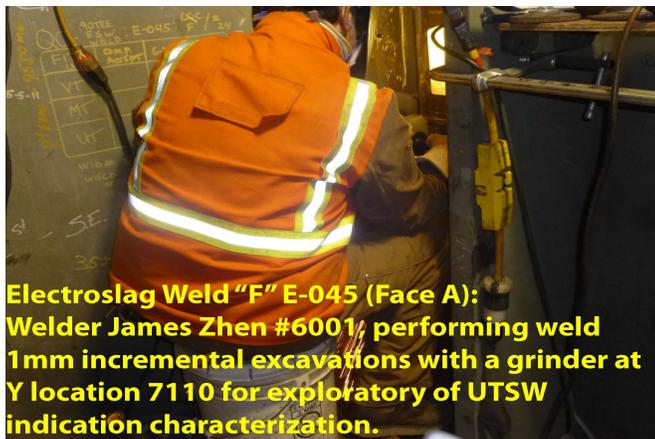
This QA performed non-destructive testing on the following:

Electroslag Weld "F" E-045 at face A:

- 1mm incremental excavation at Y 7110 from 36 to 40mm deep. (MPT Reject)
- A TL-6028 is not required for this MPT.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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**Summary of Conversations:**

Conversations this day as required for scope of work.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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